



**HARRY HERSBACH
TOOLS BV**

specialist in machining tools

COUNT LINE









COUNT LINE

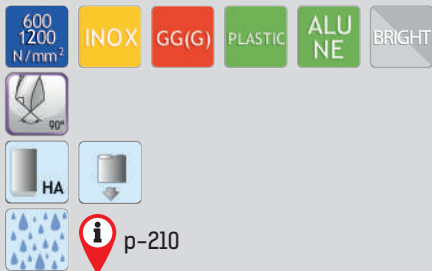
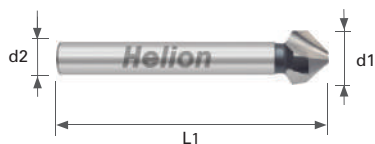


COUNT LINE	Ø range	6,30-31	6,30-31	6-20	6,30 - 8,30 - 10,40 - 12,40 - 16,50 - 20,50	6,30 - 8,30 - 10,40 - 12,40 - 16,50 - 20,50
	Code	21.0300	21.2300	21.7100	BOX2100	BOX2123
	Page	205	206	207	208	209
	Type	HSS	HSS	HSS	HSS	HSS
	Coating	Bright	TiAlN	TiN Up	Bright	TiAlN
	Coolant	-	-	-	-	-
	Shape	90°	90°	180°	90°	90°
	Shank design	HA	HA	HA	HA	HA
	Steel (600/1200 N/mm ²)	●	●	●	●	●
	Stainless steel	●	●	●	●	●
Cast iron	●	●	●	●	●	
Plastic	●	○	○	●	○	
GFK-CFK	○	●	●	○	●	
ALU-NE	●	○		●	○	
NI ALLOYS		●	●		●	

COUNTERSINKER 90° DIN 335 HSS

21.0300







-  Avellanador cónico 90° DIN 335 HSS
-  Fraise à noyer et ébavurer 90° DIN 335 HSS
-  Svasatore conico 90° DIN 335 HSS
-  Зенковки HSS 90° DIN 335
-  Havaşa 90° DIN 335 HSS
-  沉孔90度DIN335高速鋼總刀

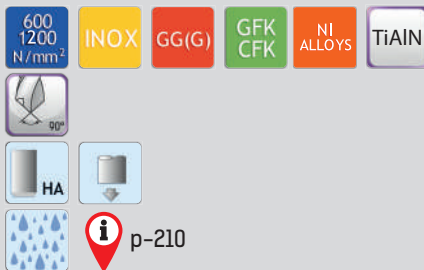


Cod.	d1	d2	L1
2103000630	6,30	5	45
2103000830	8,30	6	50
2103001040	10,40	6	50
2103001240	12,40	8	56
2103001650	16,50	10	60
2103002050	20,50	10	63
2103002500	25,00	10	67
2103003100	31,00	12	71

21.2300

COUNTERSINKER 90° DIN 335 HSS TIALN







-  Avellanador cónico 90° DIN 335 HSS TiAlN
-  Fraise à noyer et ébavurer 90° DIN 335 HSS TiAlN
-  Svasatore conico 90° DIN 335 HSS TiAlN
-  Зенковки HSS 90° DIN 335 TiAlN
-  Havařa 90° DIN 335 HSS TiAlN
-  沉孔90度DIN335高速钢TiAlN總刀

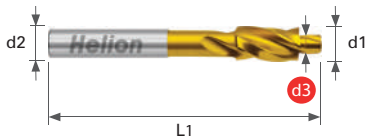


Cod.	d1	d2	L1
2123000630	6,30	5	45
2123000830	8,30	6	50
2123001040	10,40	6	50
2123001240	12,40	8	56
2123001650	16,50	10	60
2123002050	20,50	10	63
2123002500	25,00	10	67
2123003100	31,00	12	71

COUNTERSINKER 180° FINE GUIDE TOL. DIN 373 HSS TiN

21.7100

-  Avellanador cilíndrico 180° guía tol. fina DIN 373 HSS TiN
-  Fraise à lamer et chambrer 180° DIN 373 HSS TiN
-  Lamatori per sedi di viti a norma DIN 373 HSS TiN
-  Цековки с цилиндрическим хвостовиком DIN 373 HSS TiN
-  Havşa 180° ince kilavuz tol. DIN 373 HSS kalay
-  沉孔180度DIN373(精密导向) 高速钢TiN总刀



600
1200
N/mm²

INOX

GG(G)

GFK
CFK

NI
ALLOYS

TiN
Up



Cod.	M	d1	d2	d3	L1
2171000600	3	6,00	5,0	3,2	71
2171000800	4	8,00	5,0	4,3	71
2171001000	5	10,00	8,0	5,3	80
2171001100	6	11,00	8,0	6,4	80
2171001500	8	15,00	12,5	8,4	100
2171001800	10	18,00	12,5	10,5	100
2171002000	12	20,00	12,5	13,0	100

COUNT
LINE









HARRY HERSBACH TOOLS BV
specialist in machining tools

Helion 207

BOX 2100

SET BOX 6 PCS. COUNTERSINK DIN 335 90° D: 6,30 - 20,50 HSS

-  Estuche 6 pcs. Avellanadores DIN 335 90° D: 6,30 - 20,50 HSS
-  Coffret 6 pièces fraises à noyer DIN 335 90° D: 6,30 - 20,50 HSS
-  Kit 6 pezzi. Svasatore DIN 335 90° D: 6,30 - 20,50 HSS
-  случай 6 части зенкер DIN 335 90° D: 6,30 - 20,50 HSS
-  Set kutusu 6 ADET. havşa DIN 335 90° D: 6,30 - 20,50 HSS
-  D6.30-20.50, DIN335, 9度六套装高速钢总刀



600
1200
N/mm²

INOX

GG(G)

PLASTIC

ALU
NE

BRIGHT





 p-210

Cod.	Ø	Description	Norm	Type	Coating
BOX 2100	6,30	Countersink 90°	DIN 335	HSS	Bright
	8,30	Countersink 90°	DIN 335	HSS	Bright
	10,40	Countersink 90°	DIN 335	HSS	Bright
	12,40	Countersink 90°	DIN 335	HSS	Bright
	16,50	Countersink 90°	DIN 335	HSS	Bright
	20,50	Countersink 90°	DIN 335	HSS	Bright

SET BOX 6 PCS. COUNTERSINK DIN 335 90° D: 6,30 - 20,50 HSS TIALN

BOX 2123

-  Estuche 6 pcs. Avellanadores DIN 335 90° D: 6,30 - 20,50 HSS TIALN
-  Coffret 6 pièces fraises à noyer DIN 335 90° D: 6,30 - 20,50 HSS TIALN
-  Kit 6 pezzi. Svasatore DIN 335 90° D: 6,30 - 20,50 HSS TIALN
-  случай 6 части зенкер DIN 335 90° D: 6.30 - 20.50 HSS TIALN
-  Set kutusu 6 ADET. havşa DIN 335 90° D: 6,30 - 20,50 HSS TIALN
-  D6.30-20.50, DIN335, 9度六套装高速钢TIALN总刀



600
1200
N/mm²

INOX

GG(G)

GFK
CFK

NI
ALLOYS

TIALN



i p-210

Cod.	Ø	Description	Norm	Type	Coating
BOX 2123	6,30	Countersink 90°	DIN 335	HSS	TIALN
	8,30	Countersink 90°	DIN 335	HSS	TIALN
	10,40	Countersink 90°	DIN 335	HSS	TIALN
	12,40	Countersink 90°	DIN 335	HSS	TIALN
	16,50	Countersink 90°	DIN 335	HSS	TIALN
	20,50	Countersink 90°	DIN 335	HSS	TIALN

COUNT
LINE



HARRY HERSBACH TOOLS BV
specialist in machining tools

Helion 209

CUTTING CONDITIONS

Bright	TIAlN	TiN
21.0300	21.2300	21.7100



		Vc m/min	Vc m/min	Vc m/min	feed op.
Steel	General steels <500 N/mm ² (<150 HB)	32	40	35	26
	General steels <700 N/mm ² (<205 HB)	28	35	33	25
	General steels <850 N/mm ² (<25 HRC)	25	30	27	25
	General steels <1000 N/mm ² (<32 HRC)	15	20	18	24
	General steels <1200 N/mm ² (<44 HRC)	10	12	11	24
	Tempering steel <850 N/mm ² (<25 HRC)	25	30	27	24
	Tempering steel <1000 N/mm ² (<32 HRC)	15	20	18	24
Cast iron	Tempering steel <1200 N/mm ² (<44 HRC)	10	12	11	24
	Cast iron <180HB	25	30	28	25
	Malleable cast iron GTW - GTS	20	25	22	25
Non ferrous	Nodular cast iron GG - GGG	16	20	17	24
	Aluminium and AL-alloyed <6 % S	80	95	90	26
	Aluminium and AL-alloyed 6%-12% S	40	50	45	25
	Aluminium alloyed over >12% S	30	35	32	25
	Copper, long chips	60	70	65	24
	Brass, bronze, short chips	30	35	33	26
	Brass, bronze, long chips	20	28	29	26
Inox	INOX Stainless steel <700 N/mm ² (<205 HB)	16	18	17	24
	INOX Stainless steel >700 N/mm ² (>205 HB)	12	14	13	24
Exotic materials	Titanium, Ti-, Ni-, Co- alloy (Inconel, Stellite...)	8	9	9	24
	Ti 1 / Ti Al6V4	10	12	11	24

Feed OPTION			
d1	24	25	26
6,00	0,150	0,180	0,220
8,00	0,150	0,200	0,250
10,00	0,180	0,220	0,250
12,00	0,180	0,250	0,300
16,00	0,200	0,280	0,350
20,00	0,250	0,300	0,380
25,00	0,250	0,300	0,380
31,00	0,300	0,380	0,450

Conditions of work guidelines. may vary on each concrete case.
 Condiciones de trabajo orientativas. pueden variar en función de cada caso concreto.